

Date: Tuesday, 3/11/2008 1:17:25 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	L/H LOW PROFILE BASKET BASE ASS'Y	
Job Number	37814		Part Number	D371202 - 042	
Estimate Number	13145		Drawing Number	D3712 UNDER REVIEW DSS 08.03.11	
P.O. Number			Project Number	N/A	
This Issue	3/11/2008	S.O. No.	Drawing Revision	A	
Prsh Rev.	NC		Material		
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	3/17/2008
Previous Run	37286		Qty:	1	Um: Each
Written By					
Checked & Approved By					
Comment	Est Rev:A new issue 08-01-30 DD		verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TSC0750W065	304 SQ Tube.75x.75x.065W
Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s) 304 SQ Tube.75x.75x.065W		
1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.		
QTY	PART NUMBER	BATCH
2	D3726-1	<u>m107315</u>
2	D3727-1	<u>m107315</u>
2	D3734-1	<u>m107315</u>
6	D3735-1	<u>m107315</u>
3	D3739-1	<u>m107315</u>
3	D3740-1	<u>m107315</u>
2- deburr		
2.0	D23273	Spacer Bushing
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing batch <u>336479</u>		
3.0	D2581	Mounting Bracket
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket batch <u>B36481</u>		

D3759-1

QTY 21

Batch: B37663

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: L/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37814

Part Number: D3712041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D37251 HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B37626

PCL 08.03.15

5.0 D37481 HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch B37305

PCL 08.03.15

6.0 D31661 Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Batch: B37611

PCL 08.03.15

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- take D3166-1 and trim as per dwg D3746 to make D3746-1

2- take D3746-1 and drill holes as per dwg D3646

3- drill holes in both D3727-1 as per dwg D3727

4- take 1x D3735-1 and drill holes as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

PCL 08.03.15
SD 08/03/15

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PCL 08.03.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: L/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37814

Part Number: D3712041

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-15

10.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number

Description

Batch

38sq.ft M304EX0.75-16F

Expanded Metal

M10Z368

DL 08/03/15

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D

2- weld mesh as per dwg D3712

PL 08-03-15

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-15 (1)

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-15 (1)

14.0 POWDER COATING POWDER COATING



(1K)

M107005

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-1-a-n 08/03/15

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 08-03-17 (1)

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA.

mf 08-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: L/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37814

Part Number: D3712041

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DD 08/03/17

Job Completion



U 08-03-17

POSITIVE RECALL

EFFECTIVE 08-03-11 AUTH U1
RELEASED RT DATE 08-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

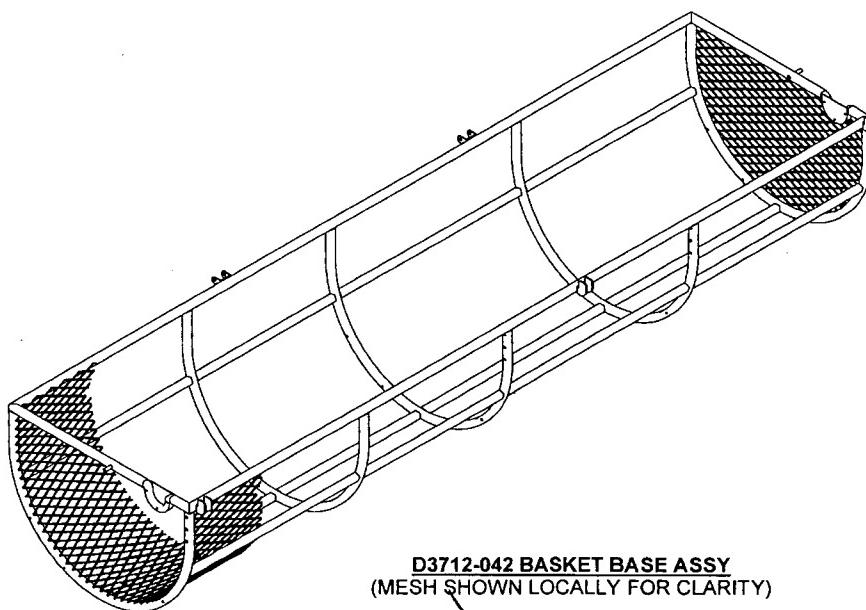
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY. 041	PART NUMBER	DESCRIPTION
X	D3712-042	BASKET BASE ASSY
2	D2327-3	SPACER BUSHING
2	D2581	MOUNTING BRACKET
2	D3725-1	HOOP
2	D3726-1	RIB
2	D3727-1	RIB
2	D3734-1	RIB
5	D3735-1	RIB
1	D3735-3	RIB
3	D3739-1	RIB
3	D3740-1	RIB
1	D3744-1	MESH
1	D3745-1	MESH
1	D3745-3	MESH
1	D3746-1	RIB
1	D3746-3	RIB
2	D3746-5	RIB
1	D3746-7	RIB
3	D3748-1	HINGE HALF
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37814

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 41.53 lbs
 - 8) WELDING: PER DART QSI 004



D3712-042 BASKET BASE ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

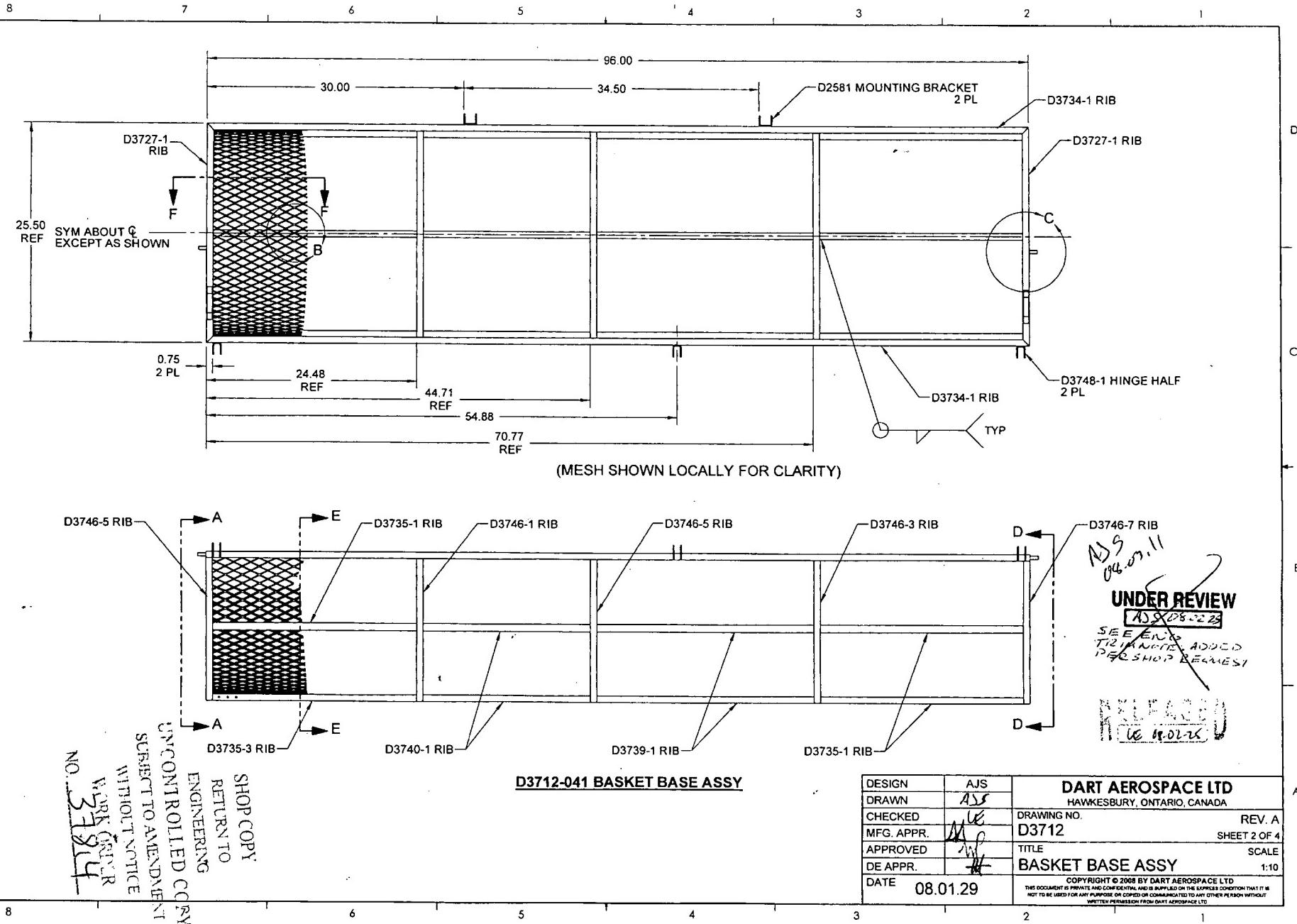
UNDER REVIEW

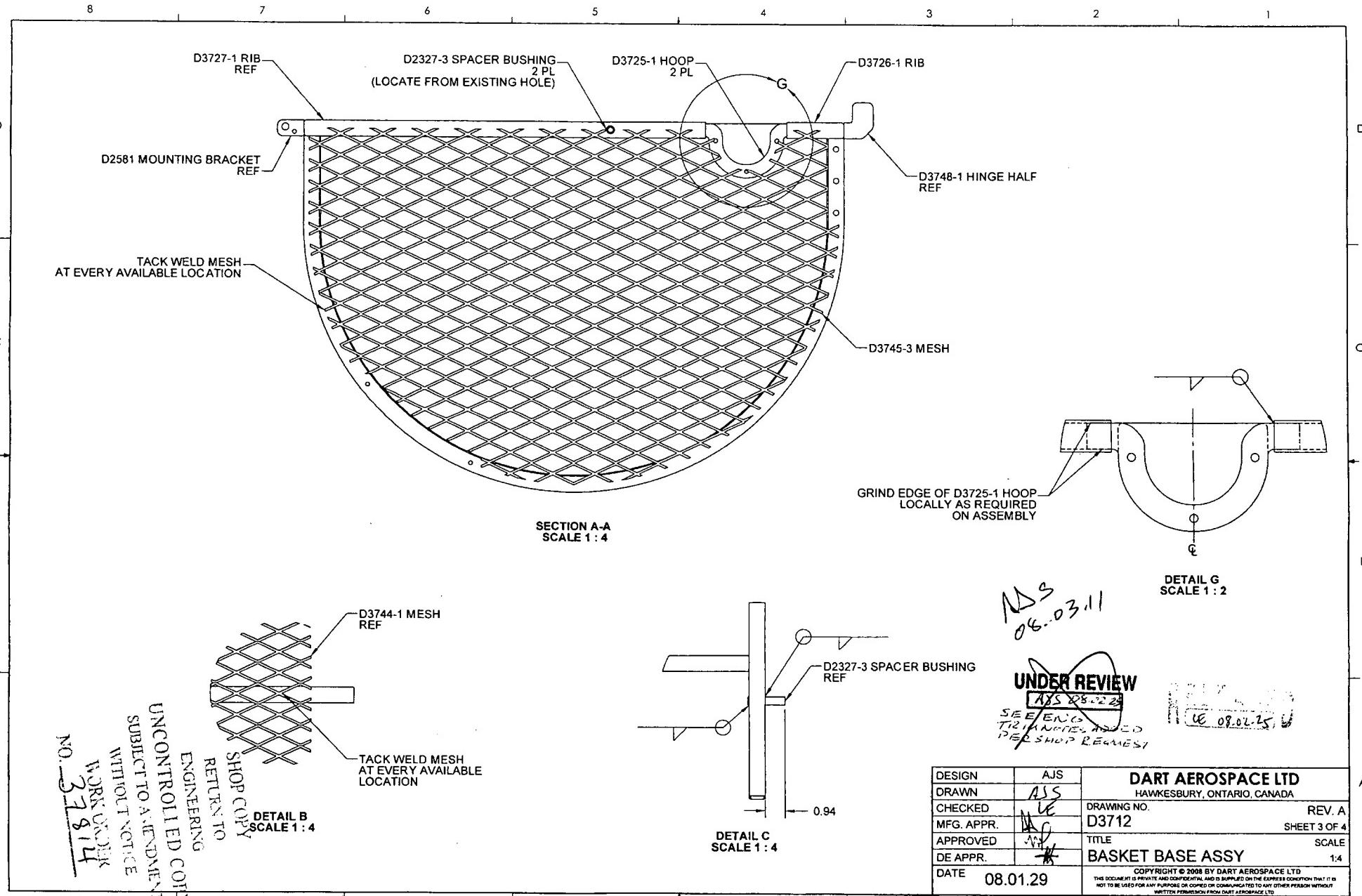
AJS 08.02.29
SIEGEN
TYPOMETER ADDED
PER SHOP REQUEST
AJ 06-03-11

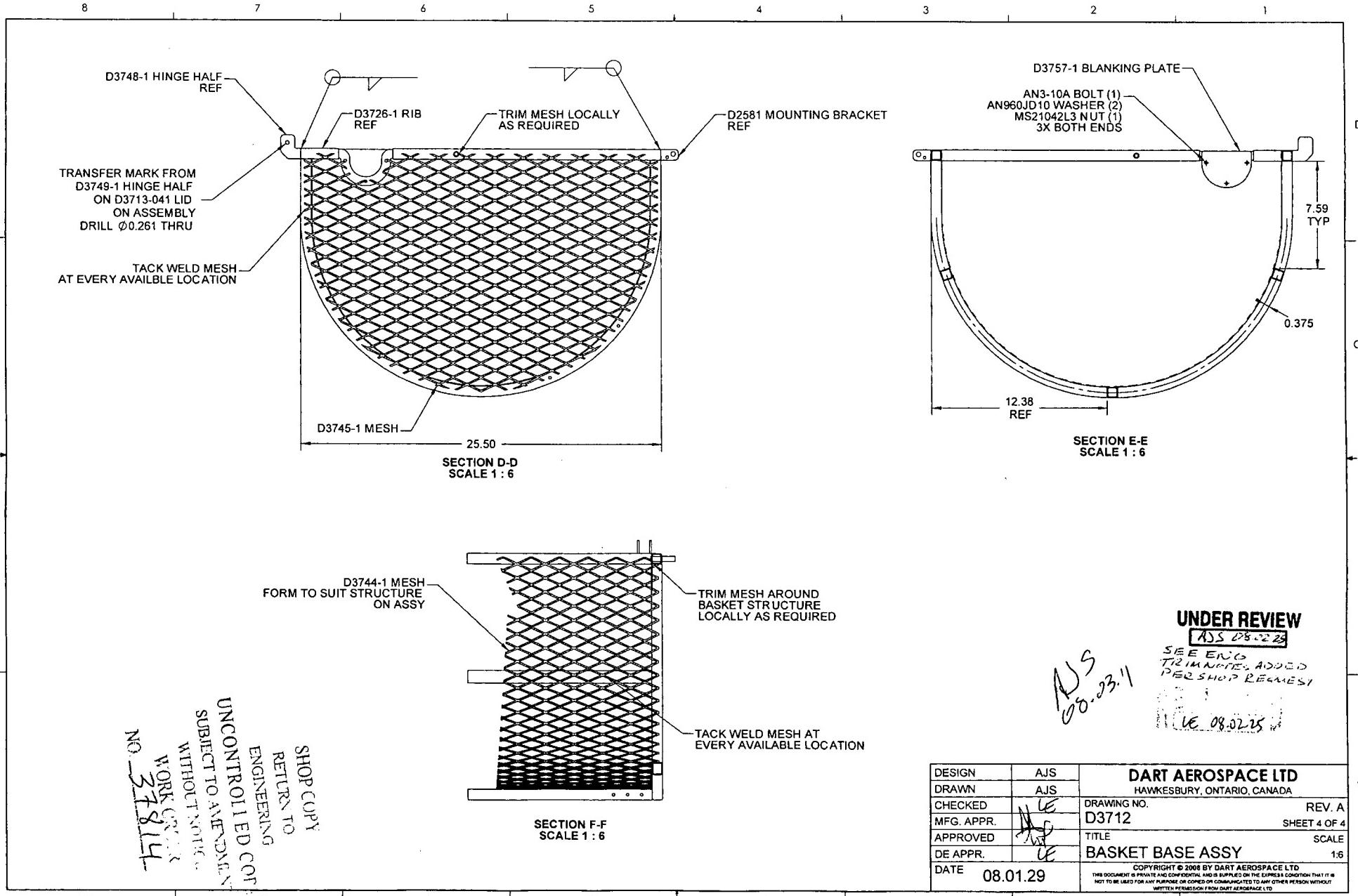
LE 08.02.29

A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IC	DRAWING NO.	REV. A
MFG. APPR.	IC	D3712	SHEET 1 OF 4
APPROVED	IC	TITLE	SCALE
DE APPR.	IC	BASKET BASE ASSY	NTS
DATE	08.01.29		

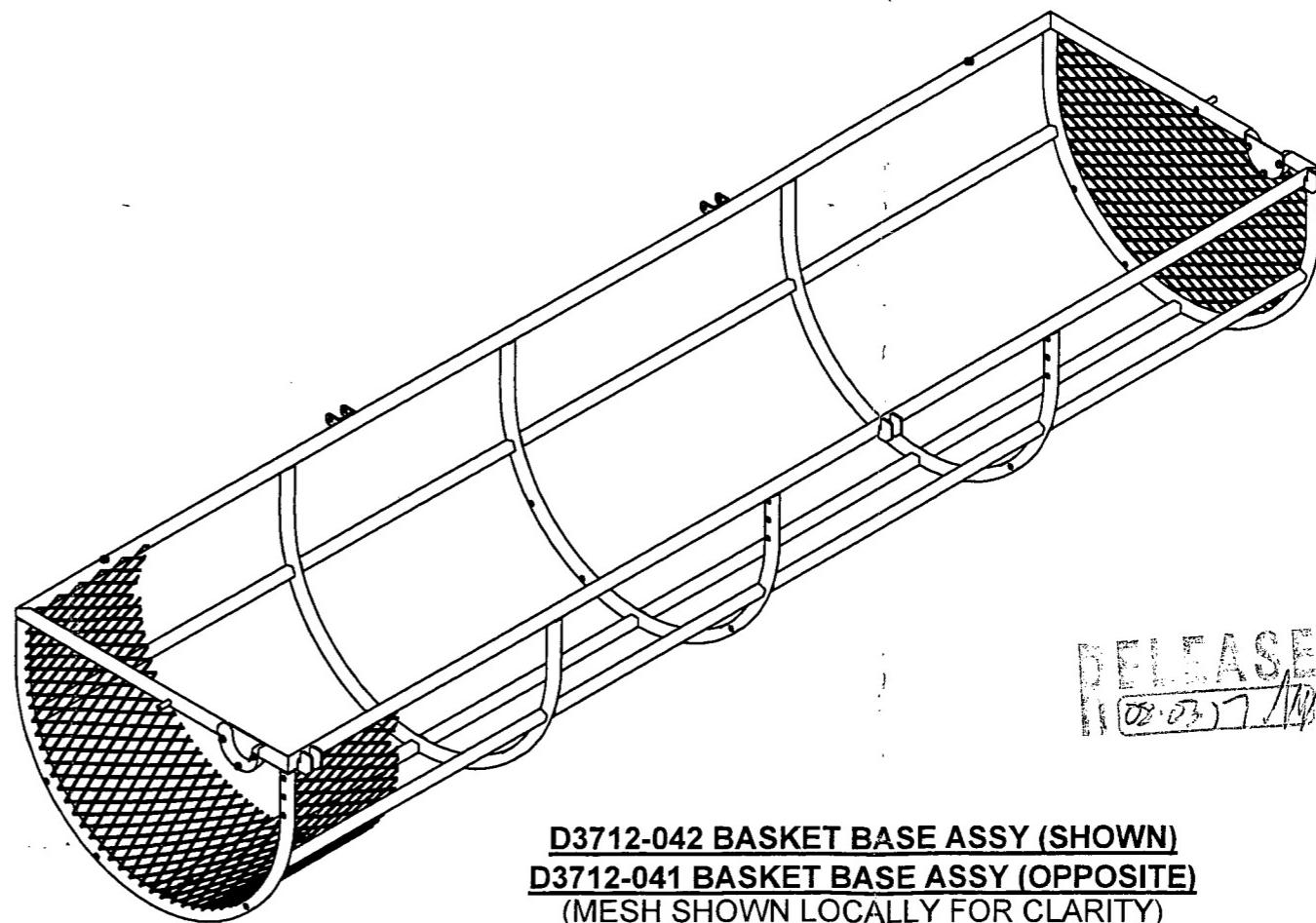
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QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3712-041	BASKET BASE ASSEMBLY
	X	D3712-042	BASKET BASE ASSEMBLY
2	2	D2327-3 ✓	SPACER BUSHING
2	2	D2581 ✓	MOUNTING BRACKET
2	2	D2931	BUMPER
2	2	D3725-1 ✓	HOOP
2	2	D3726-1 ✓	RIB
2	2	D3727-1 ✓	RIB
2	2	D3734-1 ✓	RIB
5	5	D3735-1 ✓	RIB
1	1	D3735-3 ✓	RIB
3	3	D3739-1 ✓	RIB
3	3	D3740-1 ✓	RIB
1	1	D3744-1 ✓	MESH
1	1	D3746-1 ✓	RIB
1	1	D3746-3 ✓	RIB
2	2	D3746-5 ✓	RIB
1	1	D3746-7 ✓	RIB
3	3	D3748-1 ✓	HINGE HALF
2	2	D3757-1	BLANKING PLATE
21	21	D3759-1 ✓	BUSHING
6	6	AN3-11A	BOLT
2	2	AN960JD8	WASHER
12	12	AN960JD10	WASHER
2	2	MS20600AD4W3	RIVET
6	6	MS21042L3	NUT

D3712-042 BASKET BASE ASSY (SHOWN)D3712-041 BASKET BASE ASSY (OPPOSITE)

(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004
 - 9) MASK ALL HOLES PRIOR TO POWDER COATING.

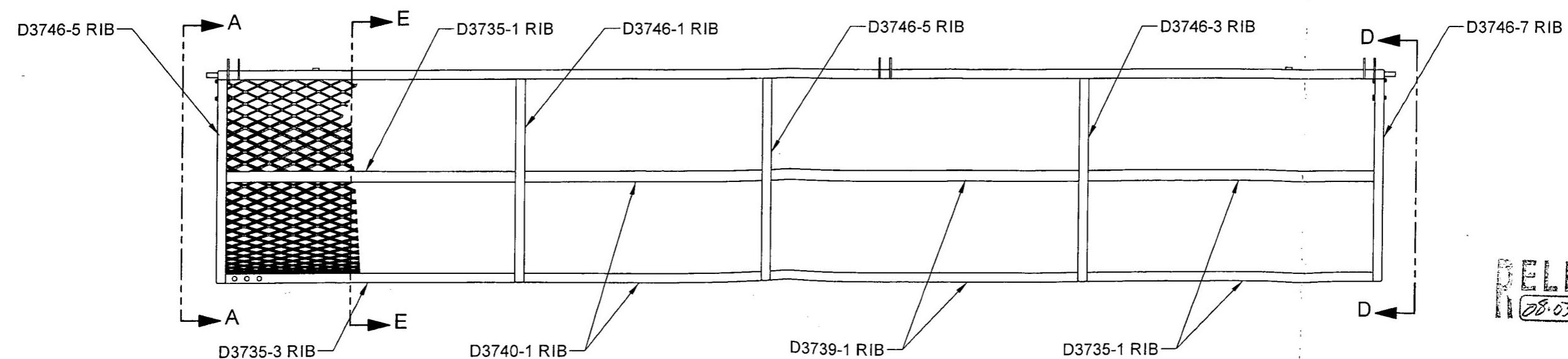
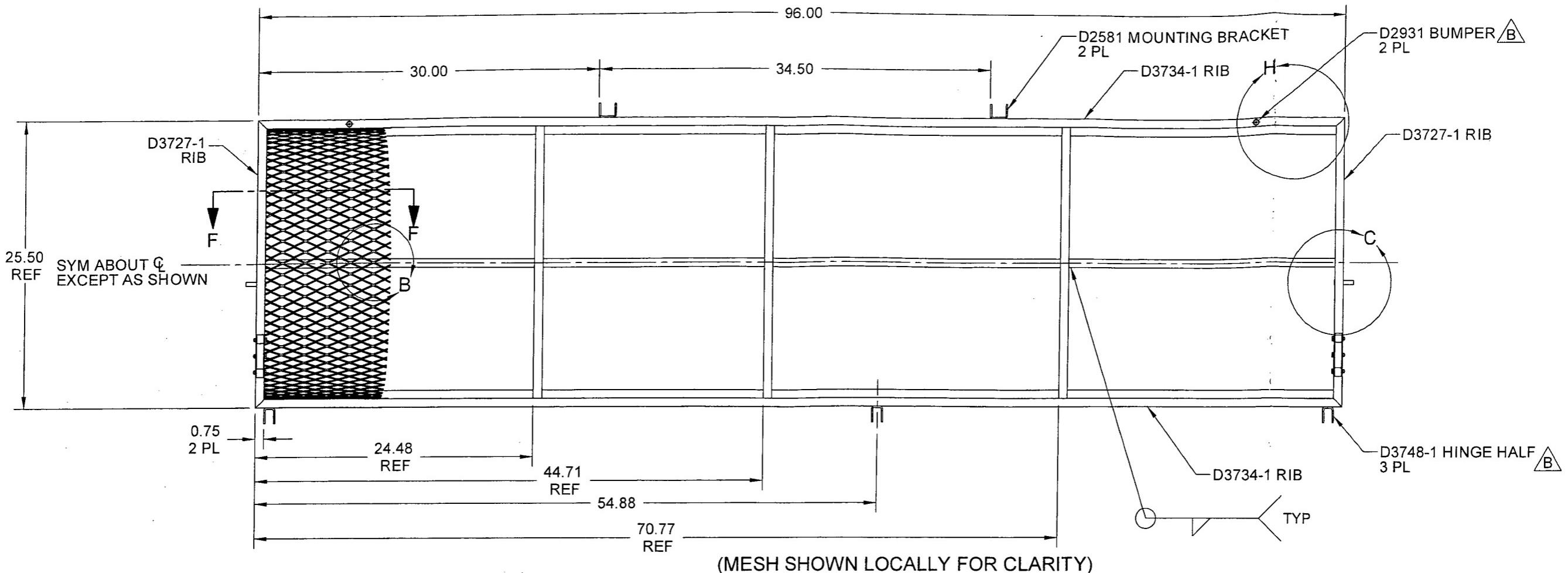
B	ADDED-041 ASSEMBLY. WEIGHT WAS 41.50 lbs. ADDED D2931 BUMPER & HARDWARE & D3759-1 BUSHINGS. SHEET 2 ZONE C2 QTY FOR D3748-1 WAS 2. SHEET 4 ADDED DETAIL H. SHEET 3 ZONE C3 & SHEET 4 ZONE C4, ADDED MESH TRIMMING INSTRUCTIONS. SHEET 4 ZONE D2 AN3-11A BOLT WAS AN3-10A P/L UPDATED ACCORDINGLY.			AJS	08.02.22
A	NEW ISSUE			AJS	08.01.29
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	CE				
MFG. APPR.	DL				
APPROVED	MF				
DE APPR.	MF				
DATE	08.02.22				

DRAWING NO. D3712 REV. B SHEET 1 OF 4

TITLE BASKET BASE ASSY SCALE NTS

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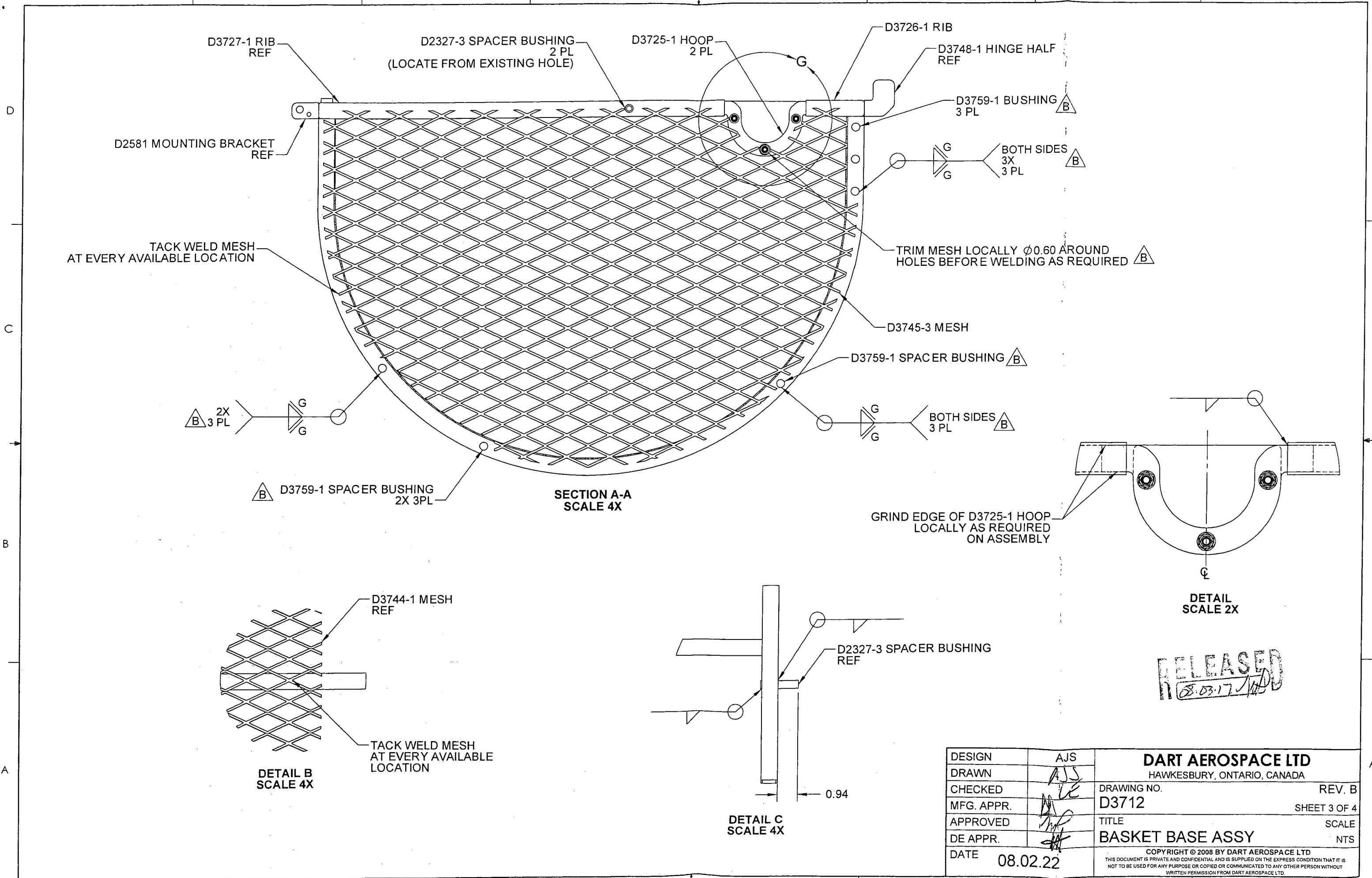


9 D3712-041 BASKET BASE ASSY (OPP)
9 D3712-042 BASKET BASE ASSY (SHOWN)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO.	
MFG. APPR.	M	D3712	
APPROVED	RJF	TITLE	
DE APPR.	MM	BASKET BASE ASSY	
DATE	08.02.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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REV B
SHEET 2 OF 4
SCALE
NTS

8 7 6 5 4 3 2 1



8

7

6

5

4

3

2

1

